

**CLAIMS**

**WHAT IS CLAIMED IS:**

1. In a belt having a plurality of spaced apart teeth, at least one tensile cord extending along the belt spaced from the teeth, and an elastomeric material filling the teeth and encapsulating the tensile cord, the improvement comprising: at least one reinforcement cord generally following along the at least one tensile cord having at least one overlay portion passing over the tensile cord and at least one loop portion extending down into at least one tooth to secure the tooth to the tensile cord.
2. A belt according to claim 1 wherein the at least one reinforcement cord comprises an alternating series of overlay and loop portions.
3. A belt according to claim 1, wherein the at least one reinforcement cord follows the tensile cord in at least one substantially spiral configuration.
4. A belt according to claim 1, wherein the at least one reinforcement cord passes alternately on the left and right sides of the tensile cord down into the belt teeth to secure the belt teeth to the tensile cord.
5. A belt according to claim 1, wherein a path of the at least one reinforcement cord along the at least one tensile cord comprises at least one helix.
6. A belt according to claim 1, wherein the belt comprises at least one reinforcement cord associated with each tensile cord.
7. A belt according to claim 1, wherein the at least one reinforcement cord wraps around a respective one plurality of tensile cords.

8. A belt according to claim 1, wherein the belt comprises a plurality of tensile cords, at least one selected tensile cord having at least one reinforcement cord wrapped therearound.
9. A belt according to claim 8, wherein at least one tensile cord remains unwrapped by a reinforcement cord.
10. A belt system of the type having at least one driven pulley and a drive belt extending about the pulley and imparting movement thereto, the driven pulley having a series of spaced teeth and the belt having a plurality of spaced apart teeth intermeshing with the pulley teeth, at least one tensile cord extending along the belt spaced from the teeth, and an elastomeric material filling the teeth and encapsulating the tensile cord, the improvement comprising:  
at least one reinforcement cord generally following along the at least one tensile cord and having at least one overlay portion passing over the at least one tensile cord and at least one loop portion extending down into a tooth to secure the tooth to the at least one tensile cord.
11. A belt system according to claim 10 wherein the at least one reinforcement cord comprises an alternating series of overlay and loop portions.
12. A belt system according to claim 10, wherein the at least one reinforcement cord follows the at least one tensile cord in a substantially spiral configuration.
13. A belt according to claim 10, wherein the at least one reinforcement cord passes alternately on the left and right sides of the at least one tensile cord down into the belt tooth to secure the belt teeth to the tensile cord.
14. A belt according to claim 10, wherein a path of the reinforcement cord along the tensile cord comprises a helix.

15. A belt according to claim 10, wherein the belt comprises a plurality of tensile cords, selective tensile cords having at least one reinforcement cord wrapped therearound.
16. In a belt having a plurality of spaced apart teeth, a plurality of tensile cords extending along the belt spaced from the teeth, and an elastomeric material filling the teeth and encapsulating the tensile cord, the improvement comprising: at least one reinforcement cord generally following along at least one tensile cord and having an overlay portion passing over the at least one tensile cord and a loop portion extending down from the at least one tensile cord.
17. A belt according to claim 16 wherein the at least one reinforcement cord comprises an alternating series of overlay and loop portions.
18. A belt according to claim 16, wherein the belt comprises a plurality of tensile cords and at least one reinforcement cord, the at least one reinforcement cord wrapping around at least one tensile cord in at least one substantially spiral configuration.
19. A belt according to claim 16, wherein the belt comprises a plurality of tensile cords, selective tensile cords having at least one reinforcement cord wrapped therearound.
20. A belt according to claim 16, wherein the at least one reinforcement cord overlay portion is positioned substantially at a space between two adjacent belt teeth and the reinforcement cord loop portion extends down and is molded into a tooth to secure the tooth to the tensile cord.